

Work Order ID 55046

January 5, 2010 1:49:32 PM



Page 1

Item ID: D3290-3

Accept

Revision ID:

Item Name: Window

Start Date: 05/01/2010 Start Qty: 20.00

Required Date: 15/01/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: PH

Date: 10-1-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3290	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

WB 10-1-14

(B)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

WB 10-1-14

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ Serially

(4/3)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55046

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Page 2

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 05/01/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Without removing protective skin remove sharp edge by degurring.

10/01/25 DL
X13

140

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg.
Rev. C Folio Rev B 2-Engrave part# &
batch#, (D3290-3)

10/01/26 DL
X13

150

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/01/26 DL
X13

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NOTE: Date & initial all entries

Work Order ID 55046

January 5, 2010 1:49:32 PM



Page 3

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 05/01/2010 Start Qty: 20.00

Required Date: 15/01/2010 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/01/26
(X13)

170

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches if required

10/01/26
(X18)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S 10/01/26

(X13)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 1:49:39 PM

Page 1

Work Order ID: 55046



Parent Item: D3290-3



Parent Item Name: Window

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MACRLICS.125

Purchased

No

100

sf

149.3670

63.1579

39



12 10-1-14

1/8" Polycast II Sheet

13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

149.367001

110115

4

110633

17.2295

111711

67.7447

112888

0.782801

113204

59.61

110633 x 2 =

113 204 x 9 + 2 = 10

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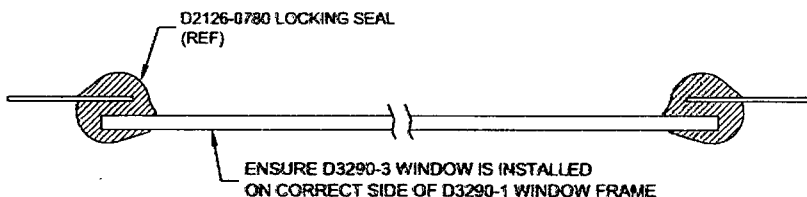
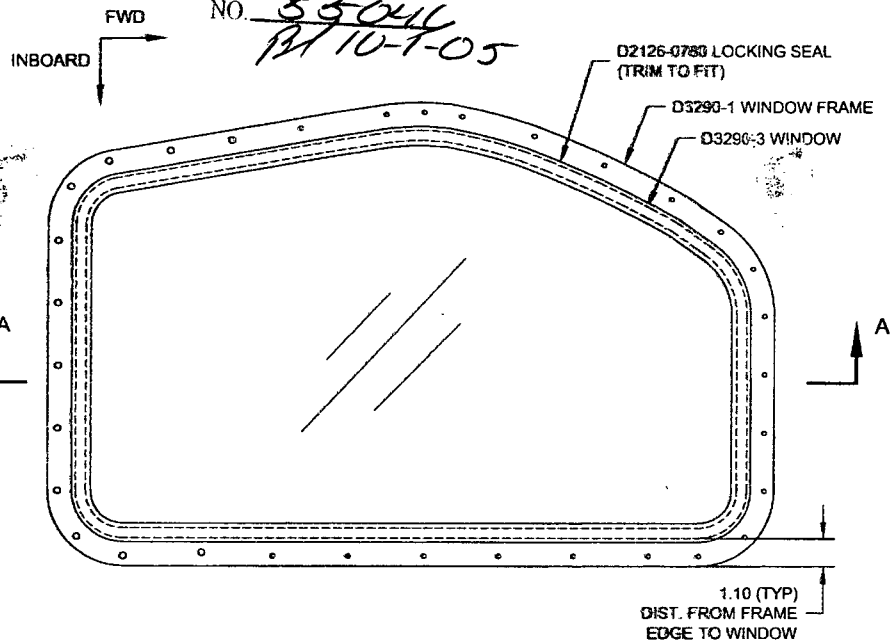
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 55044
11-10-1-05

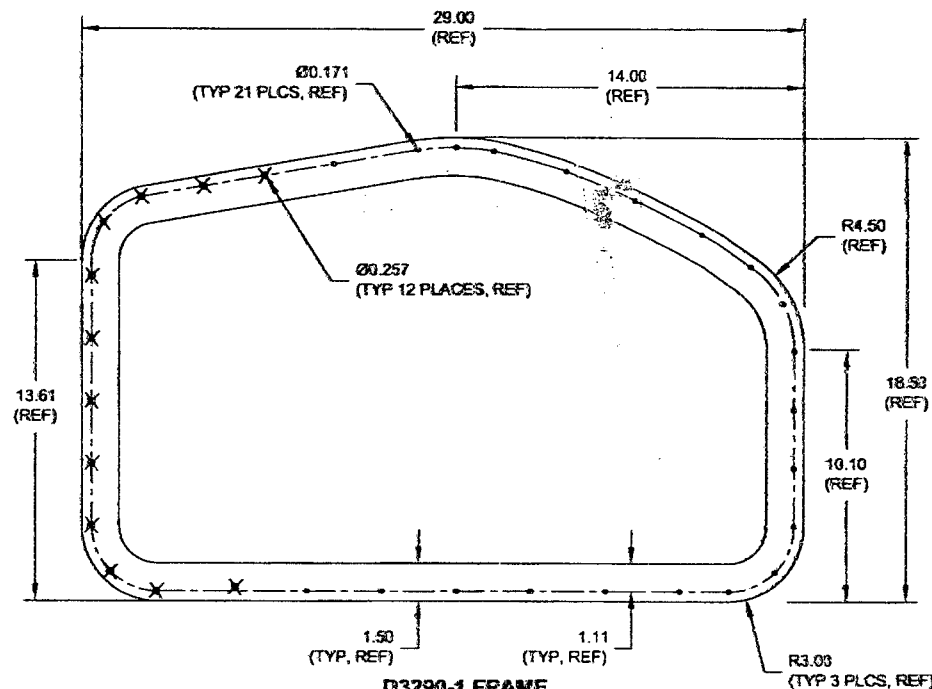


SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/18 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24

DEO ATTACHED

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 025	NB	05.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3290
TITLE REPLACEMENT WINDOW ASSEMBLY
SCALE 1:5

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UNDER REVIEW

4/09.01.18

7/07.07.24

6/9/10/19

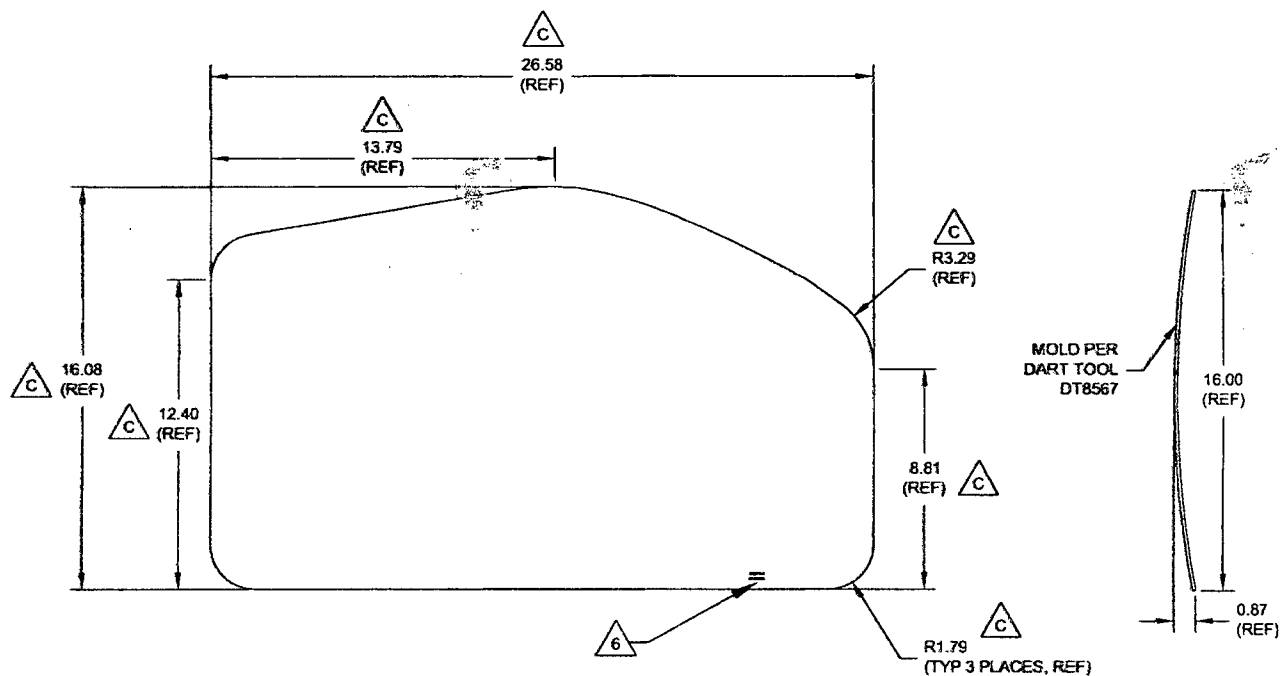
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NOTE: Date & initial all entries



D3290-3 WINDOW



D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

W/10 55044

UNDER REVIEW

DEO ATTACHED

RELEASED

07.07.24

DESIGN	<i>W/10 55044</i>	DART AEROSPACE LTD	
DRAWN	<i>DE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DE</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DE</i>	D3290	SHEET 2 OF 2
APPROVED	<i>DE</i>	TITLE	SCALE
DE APPR.	<i>DE</i>	REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE MTS
DRAWN <i>q</i>	CHECKED <i>1</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

W/O 55046

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
WMP

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